

**PROPERTY NO. 186066**

**GENERAL REQUIREMENTS**

The adhesive shall be 100% solid ethylene vinyl acetate based product, suitable for use on the Harris UB-422-Model 81-291 and Sheridan XB adhesive binders. It shall be free of objectionable odor over the normal application temperature range. The adhesive should be formulated for high speed book binding operations with in-line trimming (up to 15,000 books per hour), and exhibit good adhesion on both coated and uncoated stocks for books up to 64 mm (2-1/2")

**SPECIFIC REQUIREMENTS**

Application temperature range: 163° - 193°C (325° - 375°C)	
Viscosity, Brookfield, @ 350°F (177°C).....	3000-9000 cps
Set time.....	3 seconds
Color.....	amber or natural
Tensile strength, min.....	700 pounds per square inch
Elongation, min.....	100%

**DURABILITY REQUIREMENTS**

**SAMPLE REQUIREMENTS**

The finished book shall meet the following durability requirements.

Subway test: no loosening of pages at any location

Page pull: 35.7 g/mm (2.0 lb./in) minimum

Page flex: 125 flexes, minimum

The above durability tests will also be performed after conditioning the book at 54.4oC (130°F) for 72 hours, followed by conditioning at -5.6°C (22F°) for 72 hour, followed by condition at 25°C (77°) for 24 hours.

**PACKAGING**

The hot-melt adhesive shall be packaged as pellets in bulk (Gaylord) bins containing 545 kg (1200 pounds). The packaging and its contents shall withstand at least one-year storage under normal conditions at 45oF to 90oF (7oC to 32C).

**SAMPLE REQUIREMENTS**

A 45-kg (100 pound) sample is required for laboratory and performance test. A Material Safety Data Sheet and technical specification sheet must be submitted with the sample. The government Printing Office may purchase an additional quantity for extended testing, if necessary.

Qualified Products

H.B. Fuller: HL-3075

Coda Adhesives: 37-45

National Starch and Chemical CO.: 34-6554

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